

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018977**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Qiu Wen
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: OBG/Tower

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Flux cored Arc welding (FCAW)

Weld joint # 212 located on Grillage plate Sub assembly SA7512C for segment 13AW, P.P 119. Welder is identified as 045203. ZPMC Quality Control (QC) Inspector is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B –T -2133-Esab.

Weld joint # 208 located on Grillage plate Sub assembly SA7512C for segment 13AW, P.P 119. Welder is identified as 062708. ZPMC Quality Control (QC) Inspector is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B –T -2133-Esab.

Weld joint # 044 located on Hinge plate to Longitudinal diaphragm SEG 3020E in segment 14 W, P.P 128.3 . Welder is identified as 201215. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

variables recorded by QC appeared to comply with the WPS – B –T -2233-Esab.

Weld joint # 032 located on Hinge plate to Longitudinal diaphragm SEG 3020D in segment 14 W, P.P 128.3 . Welder is identified as 045175. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – B –T -2233-Esab.

Shielded Metal Arc Welding (SMAW)

Weld joint # 003 located on Side plate SP3103A to Side plate SP3109A, AH 3001 in segment 13AW. Welder is identified as 066261. ZPMC Quality Control (QC) Inspector is identified as Shao Jia Yuan. The welding variables recorded by QC appeared to comply with the WPS – B –P -2214 –TC –U4B –FCM -1.

Repair welding of Weld joint # 251 as per CRR no. B –CWR -2417 located on Segment 13CW Deck panel DP 3148 -001. Welder is identified as 066398. ZPMC Quality Control (QC) Inspector is identified as Shao Jia Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -FCM – Repair.

Weld joint # 226 located on Grillage plate sub assembly SA7512C for segment 13AW in P.P 119. Welder is identified as 067588. ZPMC Quality Control (QC) Inspector is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS – B –P -2212 –TC –U5 –FCM -1.

Repair welding of Weld joint # 257 as per CWR no. B –CWR -2403, located on Deck panel DP 3146 -001 in segment 13CW. Welder is identified as 045133. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -FCM – Repair.

Repair welding of Weld joint # 022 as per CWR no. B –CWR -2421, located on Deck panel DP 3133 -001 in segment 13BW. Welder is identified as 067707. ZPMC Quality Control (QC) Inspector is identified as Shao Jan Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -FCM – Repair.

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07912

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Segment 13AE at Bay #14. The weld designation reviewed as follows:

SEG 3007U – Jt. nos – 228, 234, 166, 240, 159, 246

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevent Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar,Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer